

Date: Thursday, 04/09/2008 1:23:21 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FITTING		
Job Number	: 41828			Part Number	: D32991		
Estimate Number	: 10438			Drawing Number	: D3299 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 04/09/2008	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 30/09/2008		
Previous Run	: 40301			Qty:	20		
Written By	:			Um:	12 Each		
Checked & Approved By	: <u>JUL 08.9.04</u>						
Comment	: Est Rev:A 04.10.04 New issue KJ/JLM Est Rev:B 07-06-11 Removed Manual Machining & Hex Bar JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25	(19)
		Comment: Qty.: 0.2013 f(s)/Unit Total : 2.4154 f(s) 6061T6 BAR 1.250" X1.250" Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.250"X1.250"	M104554X2 Batch: <u>M104554X2</u> mmf 08/09/14
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	(19)
		Comment: HARDINGE CNC LATHE SMALL Cut blank: 2.200" long Turn as per Folio FA451 and Dwg D3299	<u>mmf 08/09/14</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	(19)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>mmf 08/09/14</u>
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	(19)
		Comment: HAAS Machine as per Folio FA451 and Dwg D3299 CHAMFER PART USING CHAMFER MACHINE AS PER DWG D3299 Deburr	<u>DTI 08/09/19/JL</u>
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	(19)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>DTI 08/09/19</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

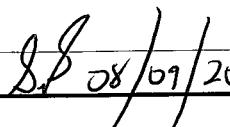
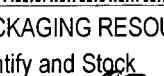
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:23:21 PM
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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: FITTING
Job Number: 41828		Part Number: D32991
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC8	SECOND CHECK  (Pn) →
Comment: SECOND CHECK		 <i>88/09/20</i>
7.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH  <i>88/09/20</i>
Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: <u>7214</u> Anodize as per Dwg D32991 Possible Supplier: TNM Paint Material release note is required		 <i>C268/09/02 (14)</i>
8.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>88/09/20 (14)</i>
Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached		 <i>88/09/20 (14)</i>
9.0	QC5	INSPECT WORK TO CURRENT STEP  <i>88/09/20 (14)</i>
10.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>88/09/20 (14)</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>82</u>  <i>88/09/20 (14)</i>		 <i>88/09/20 (14)</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE  <i>88/09/20 (14)</i>
Comment: FINAL INSPECTION/W/O RELEASE		 <i>MF 08-10-01</i>
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3299-1 PAR #: Fault Category: NCR: Yes No DQA: Date:

Resolution: Disposition: QA: N/C Closed: Date:

NCR: H1828		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/18/22	# 40	During inspection it was found that Qty (S) Parts have unsatisfactory Human unsatisfactory threatening. R.C human error	7/25/22	Scrap and Destroy no replace Qty (S)	DAP 08/09/22	08/10/22	08/10/22	S 08/09/22

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41828
Description: Fitting	Part Number:	D3299-1
Inspection Dwg: D3299 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

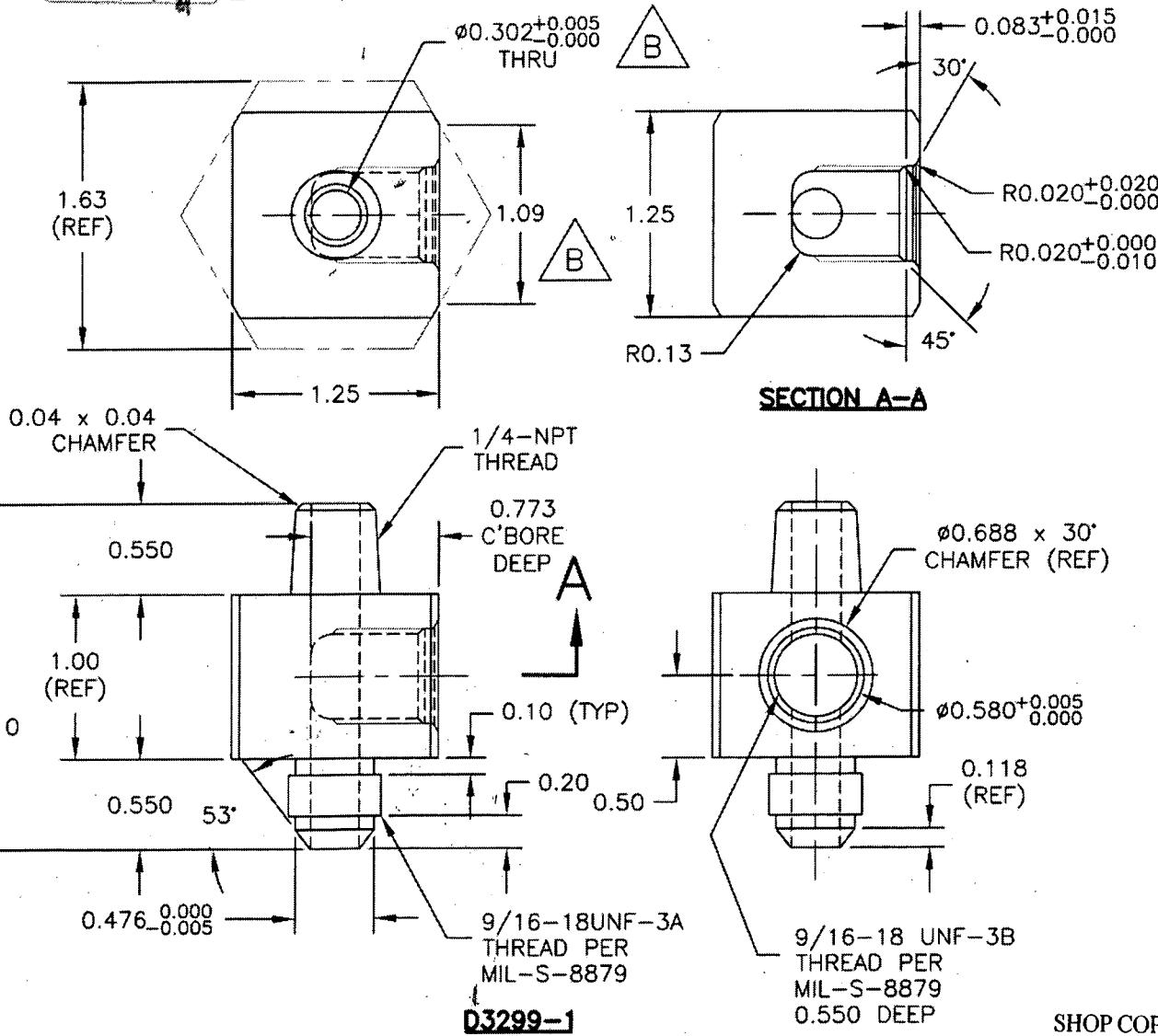
Measured by:	/JL	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	08/09/20	Date:	08/09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	AS



DESIGN <i>P</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; ϕ 0.302 WAS ϕ 0.297	

RELEASED
05.04.28



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625) ENGINEERING
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 1 UNCONTROLLED COPY POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

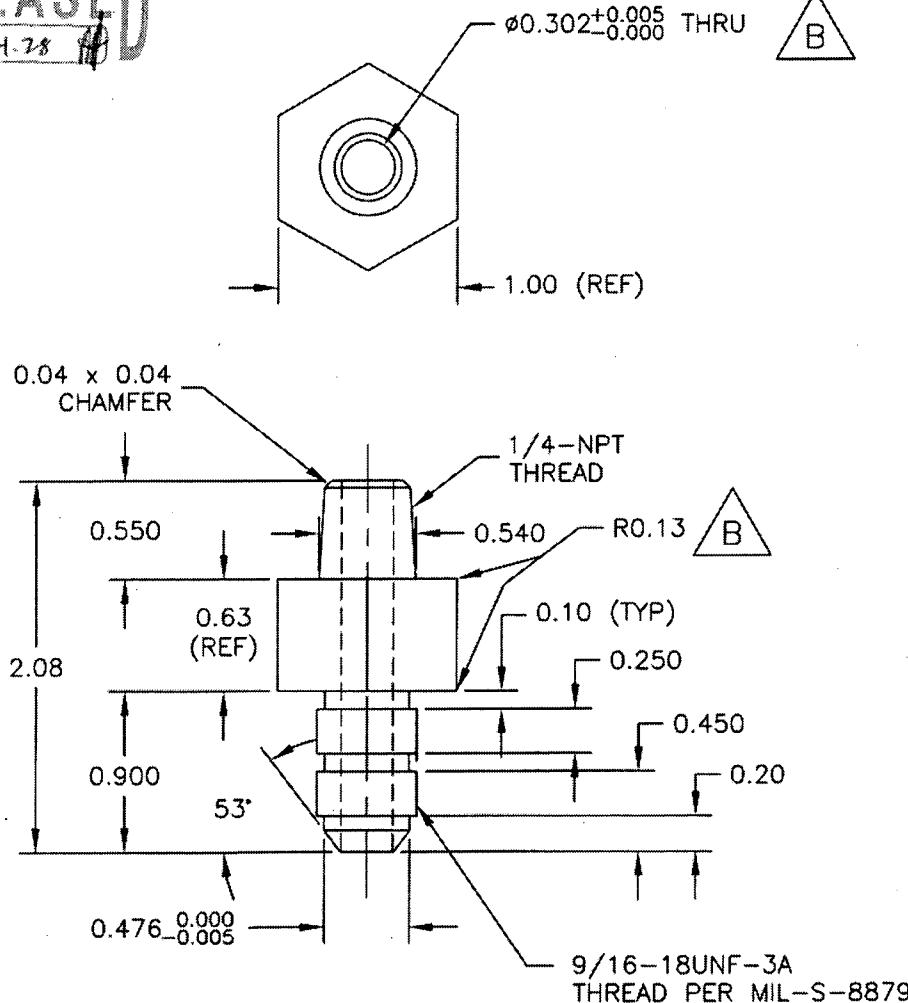
WORK ORDER

NO. 41828



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED
05.04.28



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER

NO. 91808

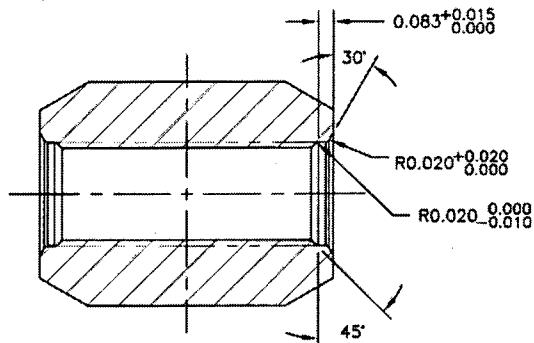
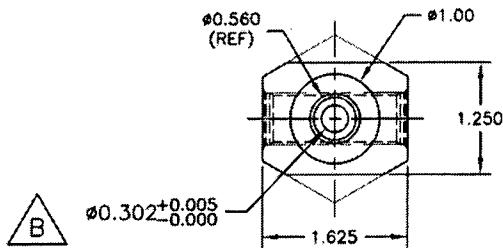
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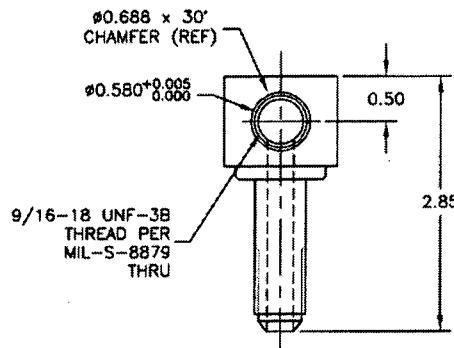
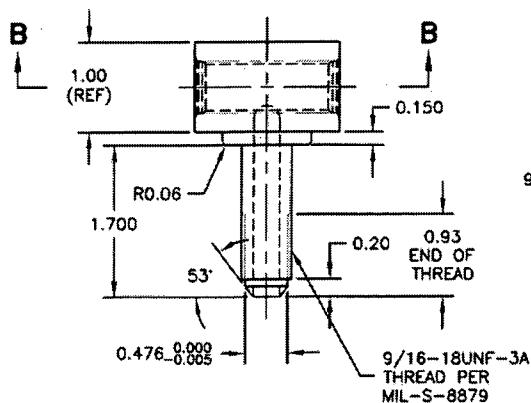


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED
05.04.28



SECTION B-B
SCALE 1:1



D3299-5

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WITHOUT NOTICE

WORK ORDER

NO. 41820

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

**FACTURE
INVOICE****68408 Rev.00**

24-Sep-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY . ONTARIO

K6A 1K7

**NO. DE COMMANDE: 7214
PURCHASE ORDER/****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER	DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	10	10	D2224 B41052	-	\$0.00	\$0.00
2	14	14	D3299-1 B41828	-	\$0.00	\$0.00
MINIMUM CHARGE						\$220.00
SUB TOTAL:						\$220.00
TPS/GST:						\$11.00
TVQ/PST:						\$0.00
TOTAL AMOUNT DUE:						\$231.00

NMINIMUM CHARGE APPLIES

No de TPS / GST # : 891559734 RT

No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE**CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû à la valeur intrinséque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 certified
 approuvé NADCAP approved

C. OF C

68408

24-Sep-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY , ONTARIO
 K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

NO. DE COMMANDE: 7214
PURCHASE ORDER/



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS/TREATMENT
1	10	10	D2224 B41052	RED ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
2	14	14	D3299-1 B41828	BLUE ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

S
 08/10/01

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
 All parts are processed, tested, and inspected to the requirements of above specifications.
 Travel cards have been filled and are available for viewing upon request.
 NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"
 NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:**Directeur de la Qualité / Q.A. Manager**